

19-7789



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RB T101530-7
Job Sheet 202449



Part No: RB T101530-7

Job Qty: 4 pcs

Part Name: Bearing Roll Stake Body



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/28/19

Job Tracking No:

Due Date: 11/29/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RB T101530 Rev.A IPP Rev. A 18.05.30 new issue DP Verify DD/IPP Rev. B 18.07.04 new DWG. DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	SL-154 - 1	4 pcs	11/29/19	11/29/19	0.00	4.00	SL-154 - 1		JB - 19.11.21
120	QC 2	4 pcs	11/29/19	11/29/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		JB 19.11.21
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		

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1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 813 632-5200
Email: sales@dartaero.com
www.dartaero.com



Container No: S233763



Part: RB T101530 - 7

Job No: 202449

Serial No/Batch: S233763

Revision: A

Inspector:

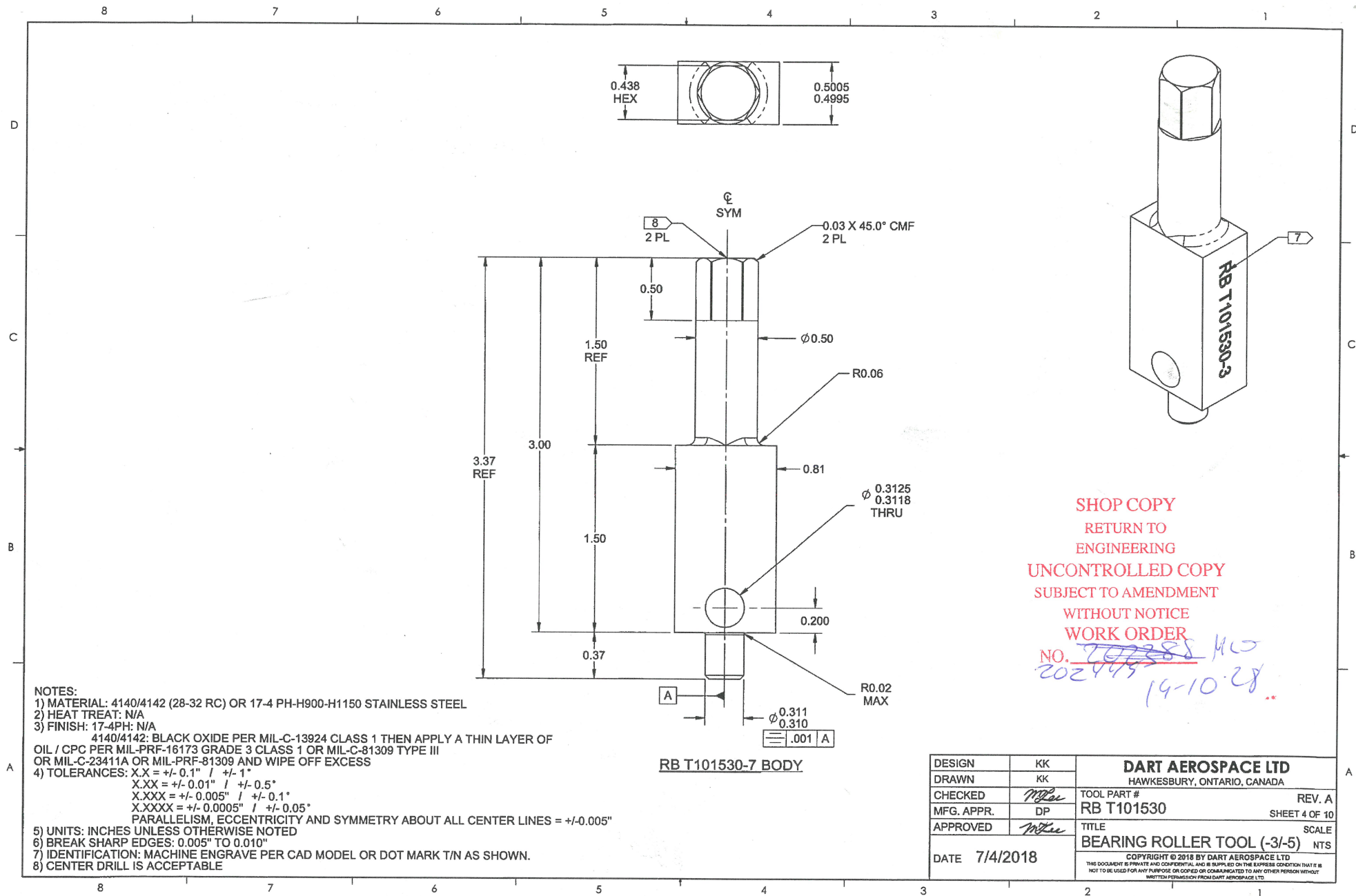
Exp Date:

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130 QC 8	4 pcs	11/29/19	0.00 0.00	QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	mm 19/11/21
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
				QC 8 - 76	
				QC 8 - 61	
140 Packaging 3-1 - Stock - B4B	4 pcs	11/29/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	DA 21 9-89
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	

				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
150 QC 21 - SA	4 pcs	11/29/19	0.00 0.00	QC 21 - SA - 21	DAS
				QC 21 - SA - 70	21 NOV 26 2019
				QC 21 - SA - 53	
Part Op 110 - MORI SL-154 LATHE 1-Machine as per DWG. FC200 FOLIO REV: <u>AA</u> DWG REV: <u>A</u> 2- Descriptions: Deburr 120 - QC2- Inspect parts off machine FAI/FAIB 130 - QC8- Inspect parts - second check - Engrave T/N and/or P/N number using MARKTRONIC engraver as per DWG. 140 - Identify as per dwg & Stock Location: _____ 150 - Identify as per dwg & Stock Location: _____					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
M17-4-H900-R1.000	17-4 SS H900 Round Bar 1.00"	1.1000 ft (.275 ea)	110-SL-154 - 1	5041668 5166337	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
110-SL-154 - 1	M17-4-H900-R1.000	1	38	0	
Part Specifications					
Specifications could not be found.					

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NOTES:
 1) MATERIAL: 4140/4142 (28-32 RC) OR 17-4 PH-H900-H1150 STAINLESS STEEL
 2) HEAT TREAT: N/A
 3) FINISH: 17-4PH: N/A
 4140/4142: BLACK OXIDE PER MIL-C-13924 CLASS 1 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS
 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
 X.XX = +/- 0.01" / +/- 0.5°
 X.XXX = +/- 0.005" / +/- 0.1°
 X.XXXX = +/- 0.0005" / +/- 0.05°
 PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 6) BREAK SHARP EDGES: 0.005" TO 0.010"
 7) IDENTIFICATION: MACHINE ENGRAVE PER CAD MODEL OR DOT MARK T/N AS SHOWN.
 8) CENTER DRILL IS ACCEPTABLE

RB T101530-7 BODY

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 WITHOUT NOTICE
 WORK ORDER
 NO. 202445 19-10-28

DESIGN	KK	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	KK		
CHECKED	<i>MB</i>	TOOL PART #	REV. A
MFG. APPR.	DP	RB T101530	SHEET 4 OF 10
APPROVED	<i>MB</i>	TITLE	SCALE
DATE 7/4/2018		BEARING ROLLER TOOL (-3/-5)	NTS
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